

Date: Tuesday, 12/05/2009 11:41:43 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L BASKET LID
Job Number : 47904B	
Estimate Number : 11274	
P.O. Number :	Part Number : D2252043
This Issue : 12/05/2009 S.O. No. :	Drawing Number : D2252 REV.G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 45976B	Material :
Written By :	Due Date : 22/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>DD 09.05.12</u>	
Comment : Est Rev: I REVISED AS PER REV E 05-12-06 JLM	
Est Rev: J 08-09-09 revF as per dwg (ecn 08-522) DD verified by: EC	
Est Rev K 09.03.18 Rev.G ecn 09-532 EC verified by: DD	

Additional Product

Job Number:

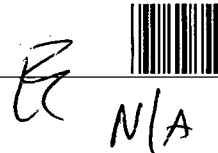


Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 32.5539 f(s)/Unit Total: 32.5539 f(s)
 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: _____



2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Cut ribs as required and weld as per DWG D2252



3.0	D22211	Rib
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Rib B47952



4.0	D22521	Frame
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Frame B46824



5.0	D22527	Frame
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Frame B47843



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:41:43 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 47904B

Part Number: D2252043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D225223	Frame
-----	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Frame B47842

PD 09.06.01

7.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2327-3	Bushing	B44365
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PD 09.06.01

8.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2329	Label Plate	B35686
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PD 09.06.05

9.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2581	Mounting Channel	B47264
---	-------	------------------	--------

PD 09.06.05

10.0	D298919	Rib
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Rib B45940

PD 09.06.01

11.0	D37491	Hinge Half
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Hinge Half B38826

PD 09.06.05

✓ 12.0	M304EX07516F	Expanded Metal Flat SS
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Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)
Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

18 sf	M304EX0.75-16F	Expanded Metal	M11630
-------	----------------	----------------	--------

SRD 09.06.02 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:41:43 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 47904B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: ~~M103~~ M108160

AD 09.06.05

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09.06.08

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/08 (K)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1ST

10:45am

2ND

1:00pm

OVEN TEMPERATURE:

400°F

400°F

FINISH TIME:

11:15am

1:30pm

09-06-10

(XC)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/06/10 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

47904

9/6/10

SV

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion



u 09.06.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

RELEASE
9/10/18

G	ADDED 'ITEM' COLUMN TO PARTS LIST. ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00". ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JJB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JJB	DRAWING NO.	REV. G
CHECKED	JJB	D2252	SHEET 1 OF 6
MFG. APPR.	JJB	TITLE	SCALE
APPROVED	JJB	BASKET ASSEMBLY (206L)	NTS
DE APPR.	JJB	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY DESIGNED.	
DATE	09.02.03		

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WORK ORDER
NO. 479048

NOTES:
1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) WEIGHT: N/A
9) WELDING: PER DART QSI 004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

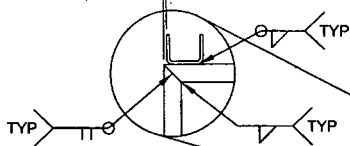
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

G 10 0.13
2 PL, REF



WELD ALL JOINTS
AS SHOWN

D2252-1

D2221-1 G

10 48.00 REF G

D3749-1
3 PL G

D2252-7

D2252-1

D2252-23

25.50
REF

G D2327-3
REF
SEE DETAIL F
B2-5

31.19

G D2989-19

31.19

D2581

TYP

D2581

30.00
9

34.50
9

30.00
REF
9

96.00±0.13 G

A

A D7-5

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NO. 1000

G D3749-1
REF




LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

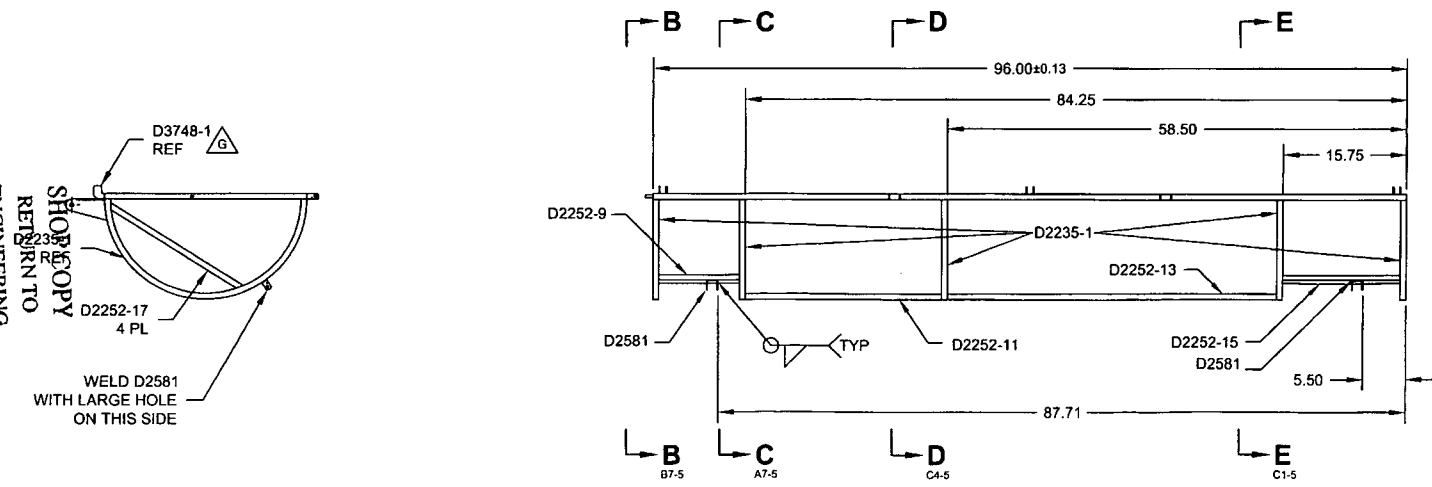
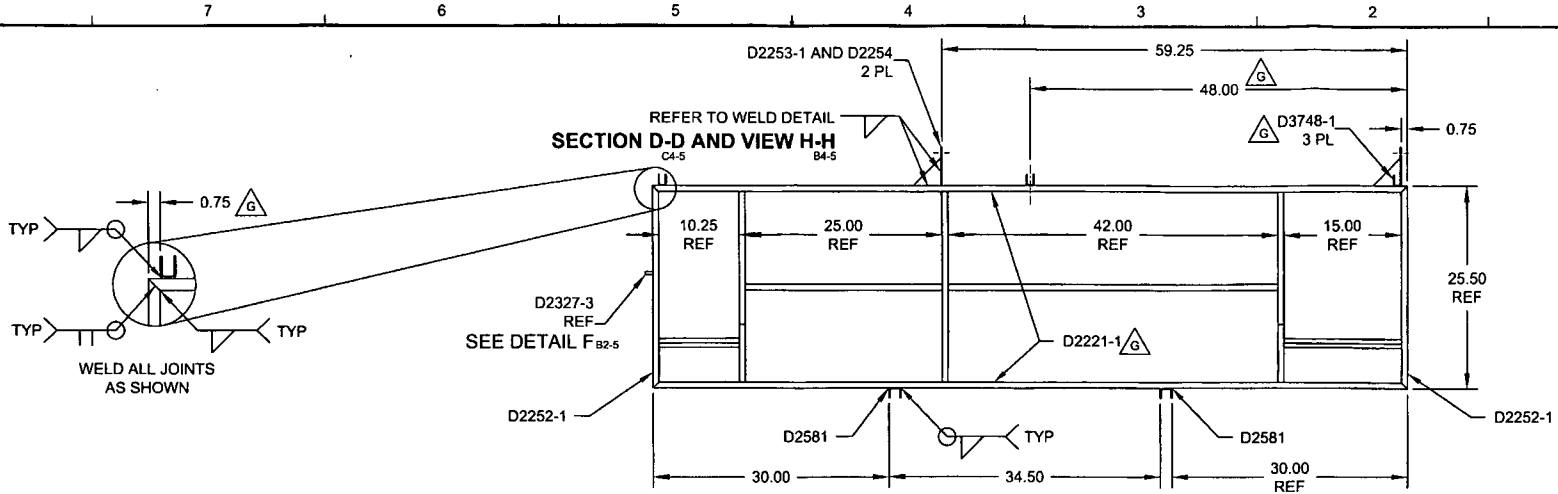
G

D2252-043 LID FRAME

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09/02/03

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 2 OF 6
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8 7 6 5 4 3 2 1



- BASE FRAME NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

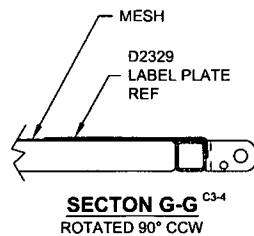
D2252-041 BASE FRAME ASSEMBLY

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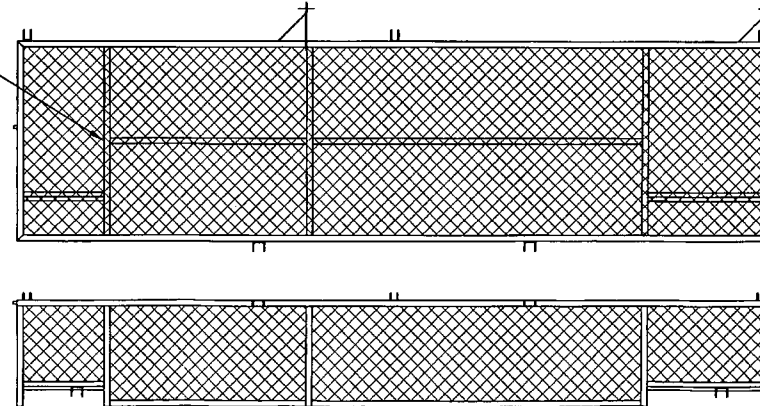
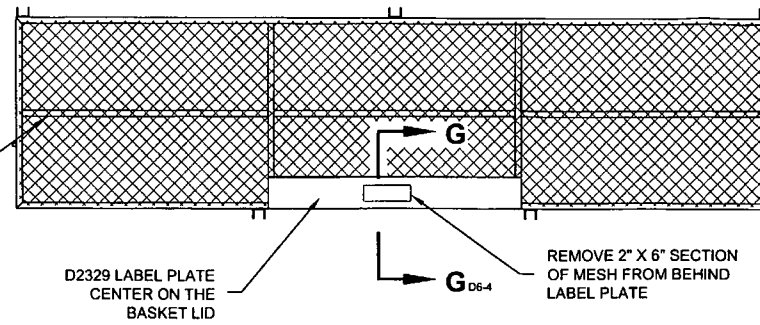
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MFG. APPR.		D2252 SHEET 3 OF 6
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D2252-17
4 PL
WELD D2581
WITH LARGE HOLE
ON THIS SIDE

8 7 6 5 4 3 2 1



TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D3748-1
3 PL. REF

TRANSFER MARK FROM D3749-1
HINGE HALF ON D2252-043 LID ASSY,
DRILL Ø0.261 THRU

0.200
PRIOR TO DRILLING Ø0.261
HOLE THRU D3748-1 AND D3749-1

D2252-043
REF

TRIM MESH LOCALLY
AS REQUIRED

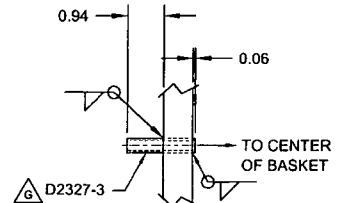
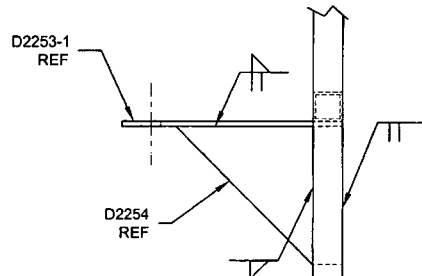
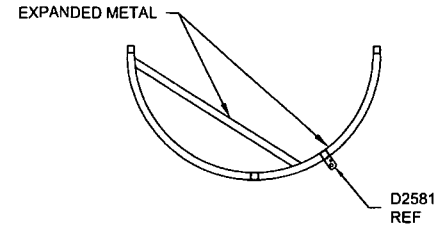
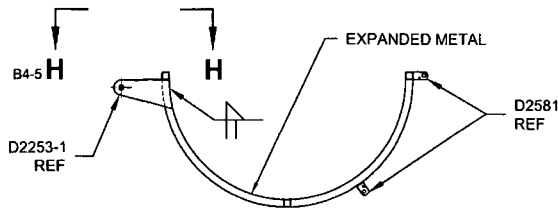
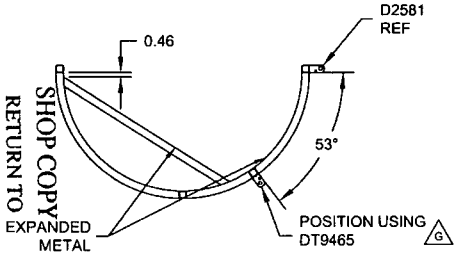
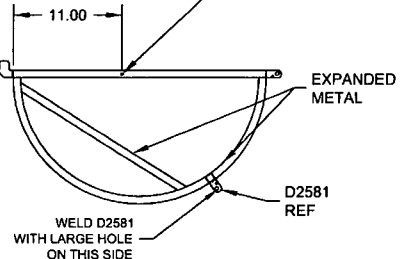
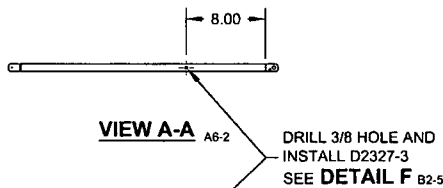
- ASSEMBLY NOTES:**
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

NO. 119041B
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MFG. APPR.		D2252	SHEET 4 OF 6
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REVISIONS
09/02/03

8 7 6 5 4 3 2 1



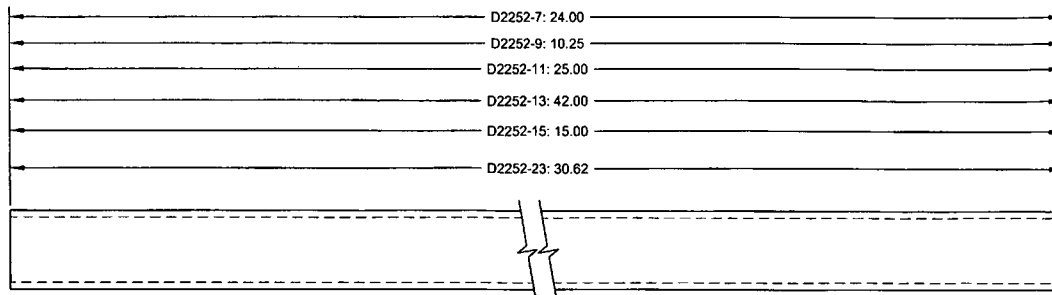
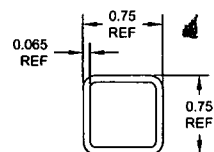
DETAIL F C5-3
SPACER INSTALLATION C6-2

RELEASED
09/02/03

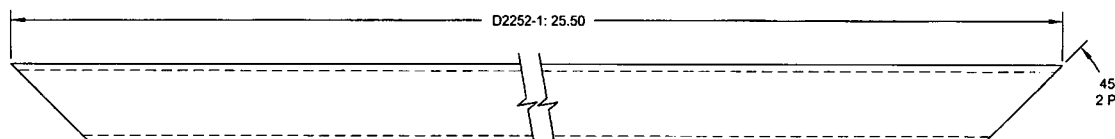
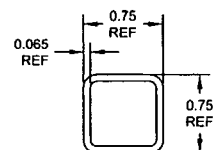
DESIGN	JB	DART AEROSPACE LTD
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CHECKED		DRAWING NO. REV. G
MFG. APPR.		D2252 SHEET 5 OF 6
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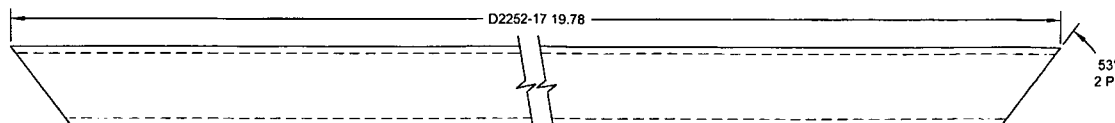
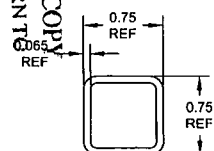
8 7 6 5 4 3 2 1



D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME



D2252-1 FRAME



D2252-17 FRAME

RELEASED
 2/2/81

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. G
MFG. APPR.		D2252 SHEET 6 OF 6
APPROVED		TITLE SCALE
DE APPR.		BASKET ASSEMBLY (206L) NTS
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